

Date: Thursday, 10/18/2007 8:03:01 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LATCH
Job Number : 35203	
Estimate Number : 12772	
P.O. Number : <u>N/A</u>	Part Number : 41232 200 002 003
This Issue : 10/18/2007 S.O. No. : <u>NA</u>	Drawing Number : 41232-200-002 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NA</u> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 31777	Material : <u>N/A</u>
Written By : <u>HA 07.10.18</u>	Due Date : 10/24/2007 Qty: 2 Um: Each
Checked & Approved By : <u>HA 07.10.18</u>	
Comment : Est Rev:A New Issue 07-03-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1875	2024 T3 ROUND BAR 1.875
-----	--------------	-------------------------



Comment: Qty.: 0.3675 f(s)/Unit Total : 0.7350 f(s)

2024-T3 Round Bar 1.250"

Batch: 117892 20 07/12/12

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: 1-TURN AS PER FOLIO FA688 & DWG 41232-200-002 ,

FOLIO REV: A

DWG REV: A

2-DEBURR AS REQUIRED

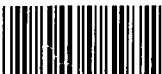
3-Tap 1/4"28NF 20 07/12/12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE 20 07/12/12 (4)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA688 Rev: A & Dwg 41232-200-002 Rev: A

2-Debur SA 07.12/16 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:01 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH

Job Number: 35203

Part Number: 41232 200 002 003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SN 07-12-16 (4)

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Mill as per Dwg 41232-200-002

2-Deburr

[Signature]

080103

(4)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature]

080103

(4)

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/01/03

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 5359

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

C20810104

(4)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

C20810114 (1)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BS 08/01/14 (x4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 394

BS 08/01/15

(x4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH

Job Number: 35203

Part Number: 41232 200 002 003

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/16

Job Completion



6 08.01.16

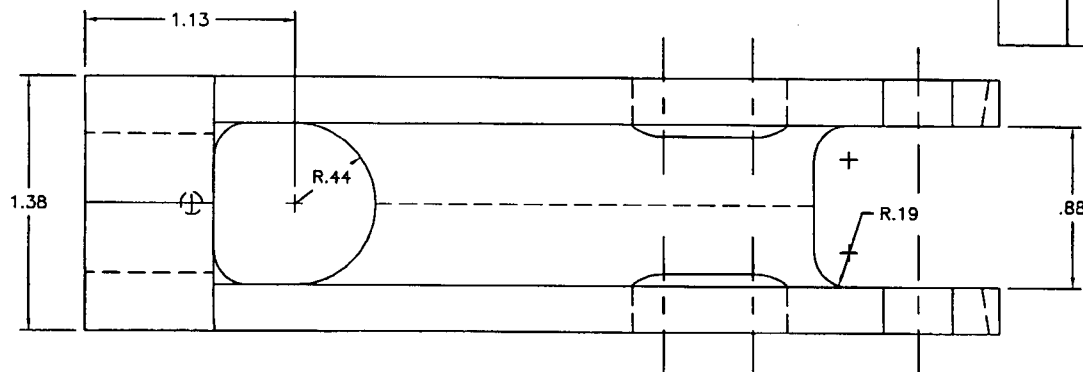
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

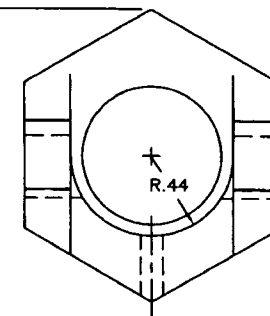
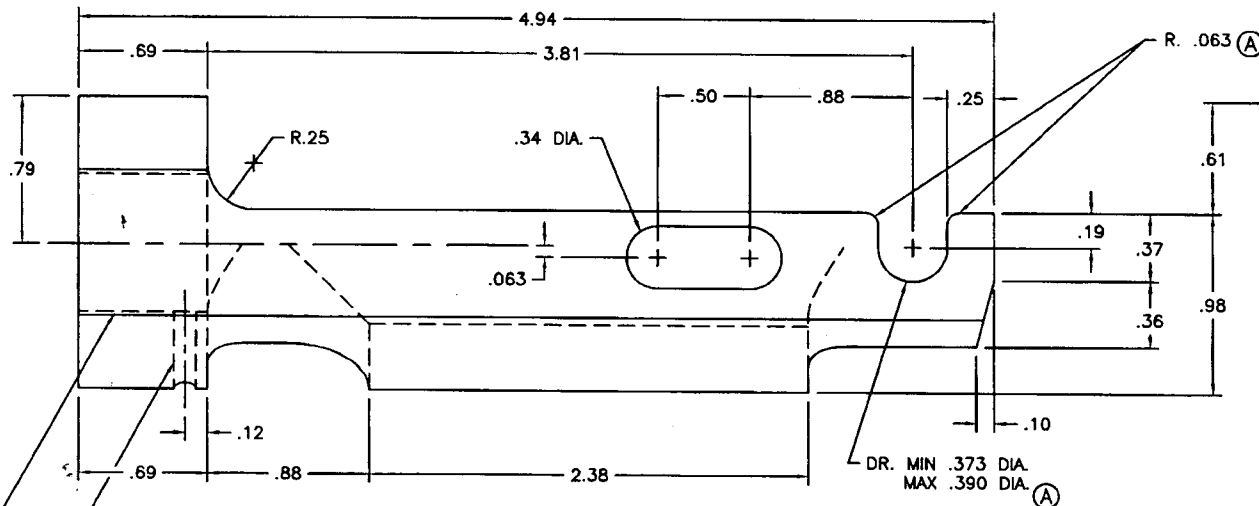
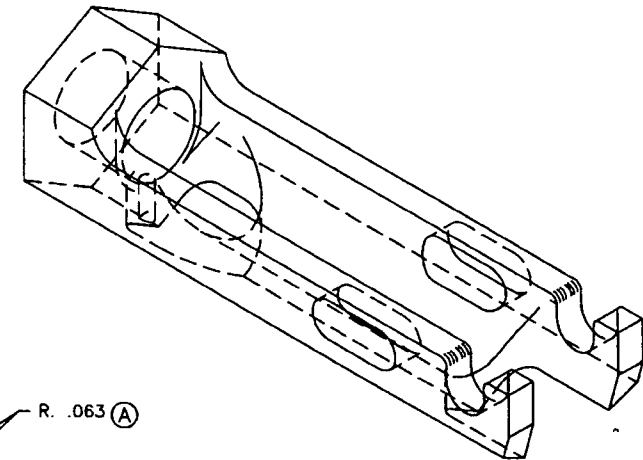
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



REVISION				APPROVED	DATE
LETTER	DFTSMAN	DATE	DESCRIPTION		
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.		
MINOR CHANGE - FAR 21.95			CHECK	D. MURPHY	2/17/03



-001 TUBE

DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE REQUIRED TO DRAIN HOLE)

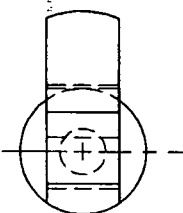
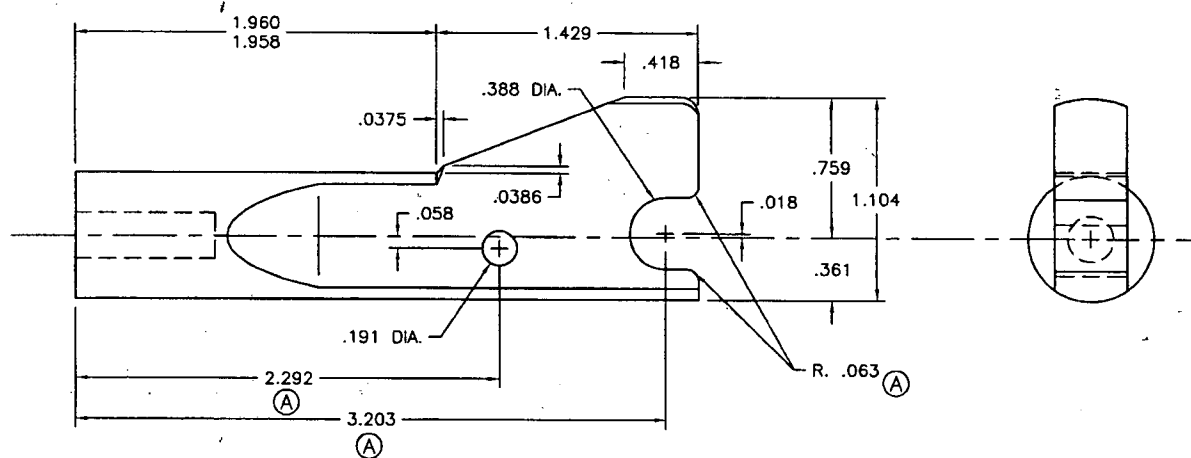
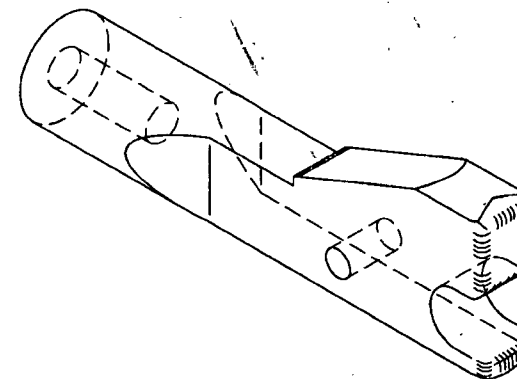
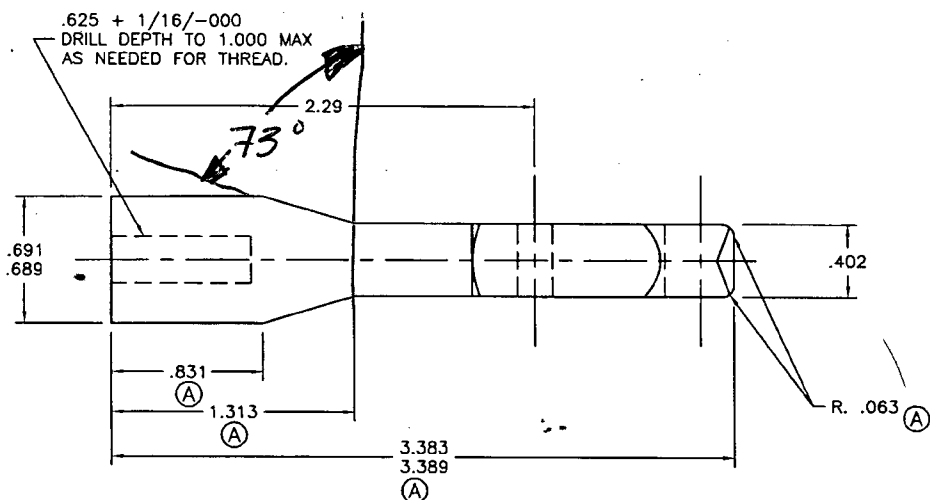
3/4"-20 THD.

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
35203

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2 DYED BLACK.

NOTE:

1	MS21209F4-15	INSERT							
	-005	PIVOT ARM	△	1.00 DIA. x 3.56	2024-T4, T351 ALUM.				
	-003	LATCH	△	1.11 x 3.50	2024-T4, T351 ALUM.				
	-001	TUBE	△	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.				
	-005	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE		
NO. REQ'D PER ASSY									
LIST OF MATERIAL									
PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED X=.1 XX=.03 XXX=.010 ANGLES .5/2		DRAFTSMAN	D. NELSON	2/18/02	STEP ACTUATOR COMPONENTS		
THESE DATA ARE PROPRIETARY TO ERM AVIATION, INC. DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT WRITTEN AUTHORIZATION FROM ERM AVIATION, INC. THE FOLLOWING DOES NOT APPLY TO VENDOR PARTS.				CHECK	D. MURPHY	2/18/02			
				STRESS					
				PROD. ENGR.					
				HEAT TREAT			DWG. SIZE	C	SCALE 2:1
				FINISH	△		Erm Aviation, Inc.		DWG. NO. 41232-200-002 SHT 1 OF 3
									REV. A



-003 LATCH

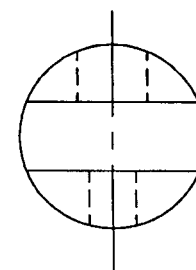
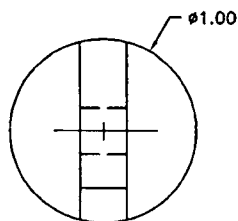
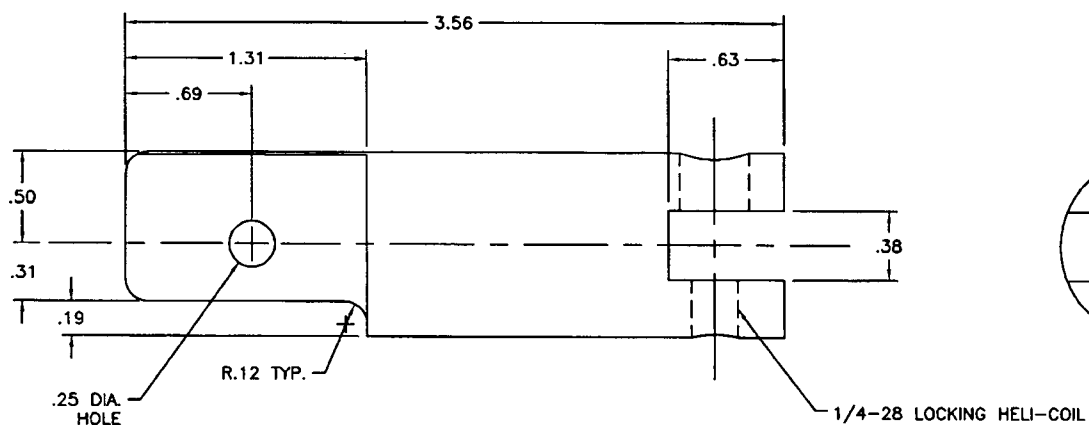
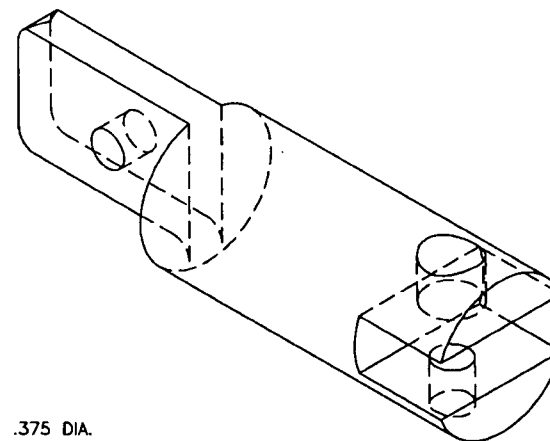
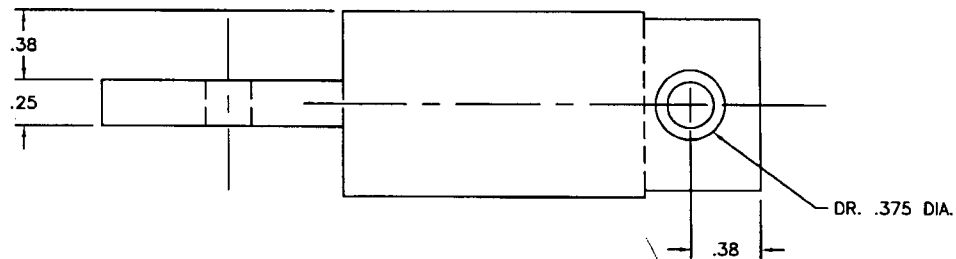
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NO. 35203

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GOING DOES NOT APPLY TO VENDOR PARTS.

Era Aviation, Inc.

TITLE	SIZE	DWG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 2 OF 3	A

35203



-005 PIVOT ARM

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TITLE STEP ACTUATOR COMPONENTS		SIZE C	DWG. NO. 41232-200-002 SHT 3 OF 3	REV. A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

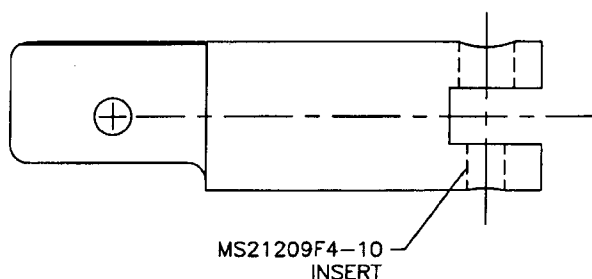
IS

1	MS21209F4-10	INSERT
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WAS

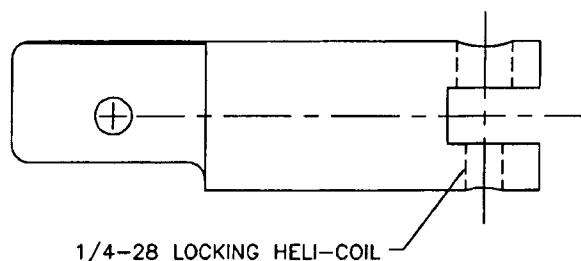
1	MS21209F4-15	INSERT
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

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WITHOUT NOTICE
WORK ORDER
35503

CHANGE REQUIRED:	DATE:	BY:	NO.	YES	NO
TRAVELER					
INSTALLATION INSTRUCTIONS					
MAINTENANCE INSTRUCTIONS					
ILLUSTRATED PARTS					
UNINCORPORATED DRAWING LIST					
MASTER DRAWING LIST					
COMPUTER DATA BASE					

DART

Purchase Order

Date Jan 04, 2008	Page 1
Purchase Order Number PO00005359	

Dart Aerospace Ltd.
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
665 01109

Vendor Address:

Anodizing & Paint T.N.M. Inc.
21 Aviation Road
Pointe Claire, QC H9R 4Z2
Phone (514) 429-7777
Fax (514) 429-5108

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		V-AND002	Jan 04, 2008	N30	Purolator	Jan 11, 2008

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
4.0000	41232 200 002 001 B	BLACK ANODIZE Comments: BLACK ANODIZE AS PER DWG D41232-200-005 ANODIZE PER MIL-A-8625F TYPE 1/1B/C/II/III CLASS 2	1/11/2008	No	11.250000		45.00
4.0000	41232 200 002 003 B	BLACK ANODIZE Comments: AS ABOVE	1/11/2008	No	11.250000		45.00

C20810114

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Comments:

Tax Summary:
GST
GSTME
GSTND

4.50
0.00
0.00

Less:

included tax

0.00

Subtotal

90.00

Total tax

4.50

Total purchase order in

CAD Dollars

94.50

Entered By *CZ* CLAVOIE

Approved By: *W*

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

61292

11-Jan-2008

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/
NO. DE COMMANDE: 5359**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	4	4	41232 200002 001 B36 47	PER DWG: 41230-200-005 BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	4	4	41232 200002 003 B35 03	PER DWG: 41230-200-005 BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MID-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"**NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.**

Signature /Signed:

Directeur de la Qualité / Q.A. Manager

